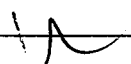


Date: Monday, 20/04/2009 10:31:33 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI UTILITY POD
Job Number	: 47282		
Estimate Number	: 12400		
P.O. Number	:	Part Number	: D350602013
This Issue	: 20/04/2009 S.O. No. :	Drawing Number	: D2202F,DEO9217A2694G
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	:
Previous Run	: 43699	Material	:
Written By	: 	Due Date	: 30/04/2009 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 06-05-01 JLM Est Rev:B Added D3495-1 06-05-17 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 09.04.29 ①.



Comment: Photocopy bluefile & type labels per PPP	D206-602-013	CHG001
---	--------------	--------

S 02/01/09





2.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
-----	----------------	--------------------



Comment: COMPOSITE ASSEMBLY

PULL FROM STOCK:

 1 X D350-602-013 B
 MODIFY PER DEO9217

F6778150550	M108932	3yds	
Hysol 9330	M110416	2KT	
Primer filler 77045	M110582	.5 LTR	
chromabase 77755	M110582	.1 LTR	

090420

3.0	D350602011	Helicopter-Pod (LH/RH)
-----	------------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit	Total : 1.0000 Each(s)
Helicopter-Pod (LH/RH)	

B 43696 090420

4.0	D30481	Doubler
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit	Total : 1.0000 Each(s)
Doubler	
Batch: 343702	
Ship to Delastek	

090420

5.0	AD64ABS	Pop Rivets
-----	---------	------------



Comment: Qty.: 46.0000 Each(s)/Unit	Total : 46.0000 Each(s)
Pop Rivets	
Batch: M108712	

090427

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
090428	2.0	Move mounting hole locations fwd and aft Approx. 1in forward of the existing holes. the incorrect hole locations to be filled with Hysol 934 sanded and touched up as Req'd. to avoid interference with nuts Hysol 934 <u>M110970</u>	<i>A</i>	090428	1	<i>[Signature]</i> 09.04.28	<i>[Signature]</i> 09.04.28

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 20/04/2009 10:31:33 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY POD

Job Number: 47282

Part Number: D350602013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS24693S272

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Screw

Batch: M110123

AA

090427

N/A

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.04.29

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE USING NEW B/N

NEW LABELS AND PAPERWORK REQ'D

JUD 09.04.29

①

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

ENSURE ORIGINAL K10002 AND

D3495-1 DECAL IN BOX

D3495-1 B43774
B46439 CHG001

D3 9652-013 CHG001 B43881

09/04/29

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/29

Job Completion



MF
09-04-29

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY ON CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P.N.	D350-602-011	CHG	CHG005		
DESC	Heli-Utility-Pod	STC	SH93-97		
LOT	B43696	STC	SR01144NY		
MODEL	AS350	STC			
MADE IN CANADA					
D2729-1					

DESIGN <i>H</i>	DRAWN BY <i>H</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. DEO 9217	REV. A SHEET 1 OF 1
DATE 01.09.26		TITLE MOsaic POD MODIFICATION	SCALE NTS
A	01.09.26	NEW ISSUE	

DART ENGINEERING ORDER

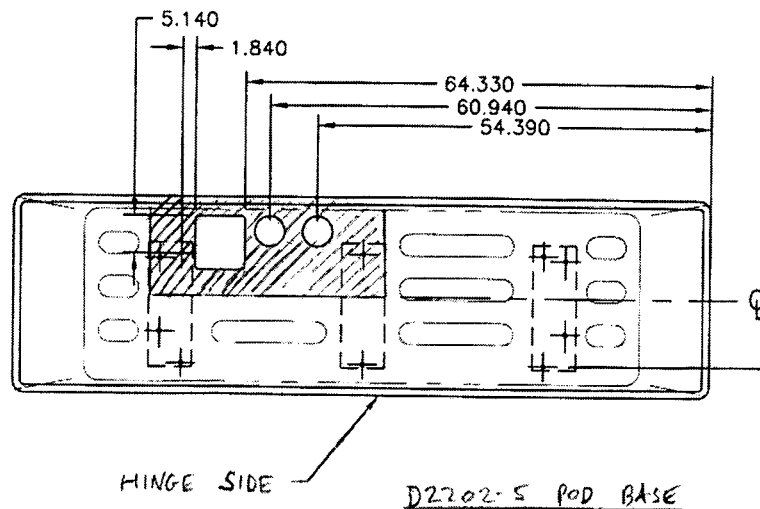
TO AMEND D2202 REV. F

TO MAKE A D2202-S BASE (FOR D350-602-013) FROM A D2202-3 BASE :

- 1) REMOVE FOAM IN SHADED AREA OF POD.
- 2) FILL GAPS WITH 902 SATIN AND RESIN PER DWG (APPROX. 3-4 LAYERS)
- 3) 2 LAYERS OF 902 SATIN
- 4) INSTALL D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) INSTALL DOUBLER WITH AD64ABS RIVETS (46) AND MS24693S272 SCREWS (3)
- 6) CUT HOLES AND SEAL WITH CYANOACRYLATE GLUE
- 7) TOUCH UP SPACKLE GREY FINISH AND CLEARCOAT

RELEASED

04.10.14 *H*



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